Dart Aerospace Ltd.

Date: Wednesday, 6/6/2007 1:59:19 PM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: PEDAL LOCK
Job Number	: 32806		
Estimate Number	: 12342		
P.O. Number	:	Part Number	: D3368041
This Issue	: 6/6/2007 S.O. No. :	Drawing Number	: D3368 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 30977	Material	:
Written By	:	Due Date	: 6/15/2007 Qty: 2 Um: Each
Checked & Approved By	: 07.06.07		
Comment	: Est Rev:A Removed from 9 Digit 06-03-22 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D33681	Pedal Lock Base

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D3368-1 BASE B22249

Seq. #:	Machine Or Operation:	Description :
2.0	D33683	Pedal Lock Cover

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D3368-3 COVER B23535

Seq. #:	Machine Or Operation:	Description :
3.0	D27287	Decal

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D2728-7 Decal B22554

Seq. #:	Machine Or Operation:	Description :
4.0	D33737	Cam Lock

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 D3373-7 Cam Lock ~~B22610~~, B22944, ~~B26212~~

07/06/12

Form: prprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: _______ Fault Category: __________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:59:19 PM
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Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** PEDAL LOCK

Job Number: 32806 **Part Number:** D3368041

Job Number:

Seq. #:	Machine Or Operation:	Description :
5.0	D33853	Hinge

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3385-3	Hinge	B22387

PTO

Seq. #:	Machine Or Operation:	Description :
6.0	238028	3/16" Dowel Pin .5" long

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
3	238-028	Ø3/16" Dowel Pin ½" long	M16958

Seq. #:	Machine Or Operation:	Description :
7.0	385039	8-32 Flat screw

Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	385-039	Flat Head Screw	M17356

Seq. #:	Machine Or Operation:	Description :
8.0	D33841	Cyclic Sock

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3384-1	Cyclic Sock	B26372

Seq. #:	Machine Or Operation:	Description :
9.0	CBL460	Loop Sleeve

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	CBL-460	Loop Sleeve	M103927

[signature] 04/06/12

Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ________ **PAR #:** ______ **Fault Category:** ________ **NCR:** Yes (No) **DQA:** D **Date:** 08/03/04

QA: N/C Closed: _____ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B: Initial Chief Eng	Corrective Action Section B: Action Description Chief Eng	Corrective Action Section B: Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
07/06/13	5	Tried to match holes of D3368-1/-3 on hinge Scrap 3 hinges	QS1042	Scrap ~~three~~ hinge D3385-3 replace by New one, Same latches.	ML 07/06/14	07-06-28	QS1042	07-06-28

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:59:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services **Drawing Name:** PEDAL LOCK

Job Number: 32806 **Part Number:** D3368041

Job Number:

Seq. #:	Machine Or Operation:	Description :
10.0	CBL1240	Cable

Comment: Qty.: 2.3333 f(s)/Unit Total : 4.6666 f(s)
Pick:
Qty Part Number Description Batch
28" CBL-1240 Cable M102439

11.0	AN960416	Washer

Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pick:
Qty Part Number Description Batch
2 AN960-416 Washer M5519

12.0	HX81	1/4"-20 SHCS 3/8" long

Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
Pick:
Qty Part Number Description Batch
1 HX-81 ¼"-20 SHCS 3/8" long M16971

07/06/12 (2)

13.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1

Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Open D3373-7 lock package. Keep keys, lock body, lock body nut, screw, flat cam and lock barrel. Discard the rest.

2-Fabricate D3371-5 Cam Lock as per Dwg D3371Identify as D3371-5 ✓

3-Assemble lock mechanism and cam and install decal as per Dwg D3368. Apply 262 locktite to lock body nut. Ensure mechanism works properly (open/close).
Pick:
Qty Part Number Description Batch
A/RN/A 262 Locktite M100410

4-Assemble lanyard to cyclic sock as per Dwg D3384

5-Assemble D3384-047 to D3368-051 using ¼"-20 socket head cap screw and washer as per Dwg D3368 X2

6-Ensure that keys are attached to D3368-041 ml 07/06/18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ PAR #: ________ Fault Category: ________________ NCR: Yes No DQA: _____ Date: _________

QA: N/C Closed: _____ Date: _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Date: Wednesday, 6/6/2007 1:59:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PEDAL LOCK

Job Number: 32806

Part Number: D3368041

Job Number:

Seq. #:	Machine Or Operation:	Description :
14.0	QC5	INSPECT WORK TO CURRENT STEP
		08.02.27 (2)
	Comment: INSPECT WORK TO CURRENT STEP	Keys C420A X2
15.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 491	8/3/3 56 (2X)
16.0	QC21	FINAL INSPECTION/W/O RELEASE
		(2)
	Comment: FINAL INSPECTION/W/O RELEASE	08/03/04

Job Completion 2008/3/04 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________________ **PAR #:** _______ **Fault Category:** _________________ **NCR:** Yes No **DQA:** _____ **Date:** _________

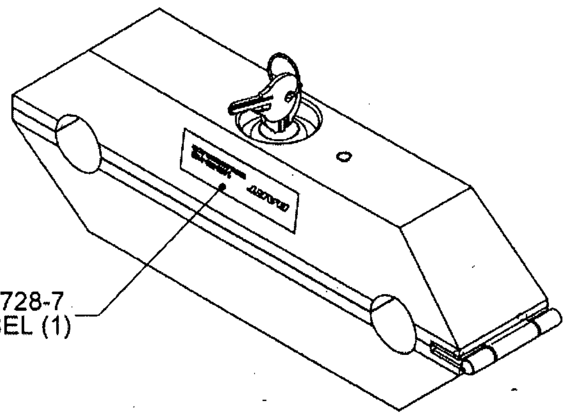
QA: N/C Closed: _____ **Date:** _________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

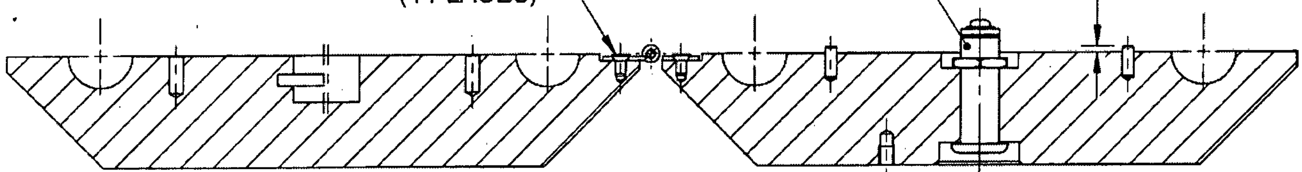
NOTE: Date & initial all entries

DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3368	REV. B SHEET 1 OF 3
DATE 05.03.22		TITLE PEDAL LOCK	SCALE 1:3
A	05.01.19	NEW ISSUE	
B	05.03.22	D3385-3 WAS D3385-1	

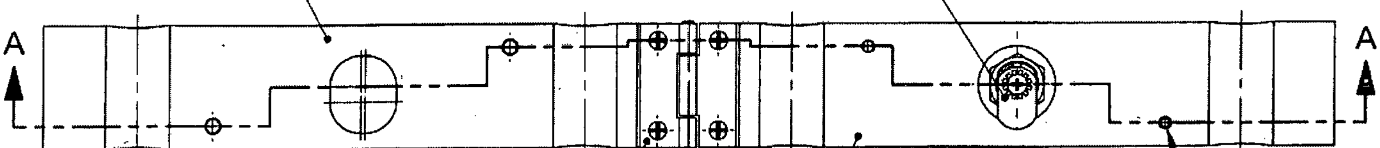
RELEASED 05/04/28



PEDAL LOCK SHOWN LOCKED WITH KEY



SECTION A-A



SHOP COPY
RETURN TO
ENGINEERING

D3368-051 PEDAL LOCK ASSEMBLY

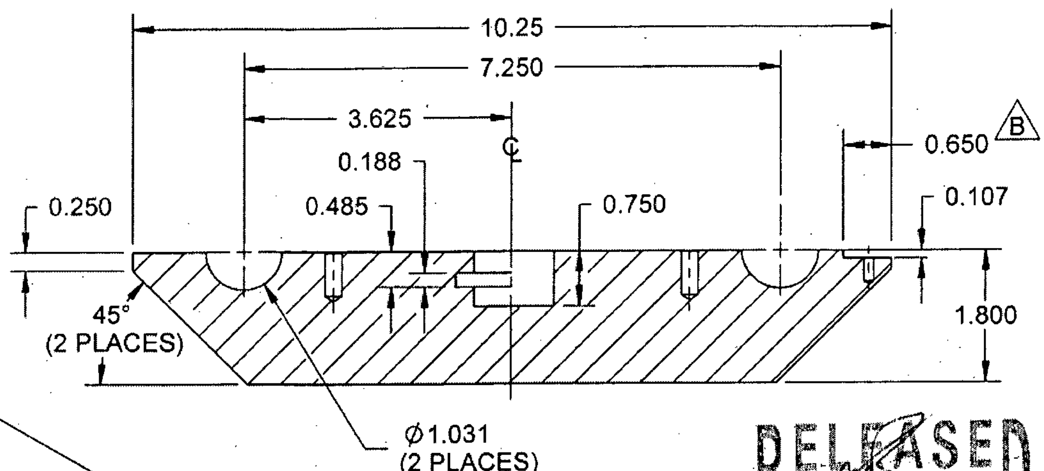
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32806

NOTES:

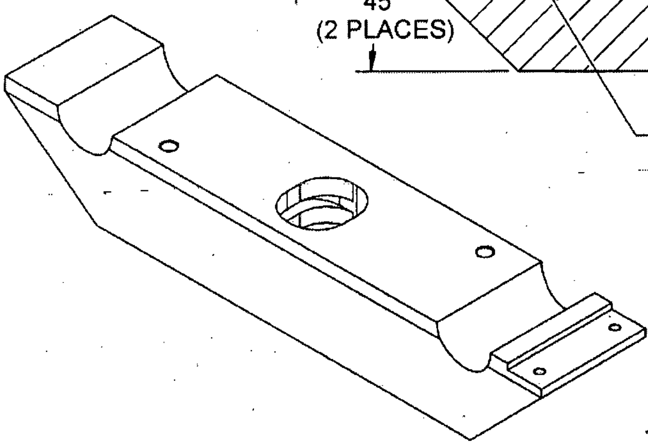
1) POSSIBLE SUPPLIER: SPAENAUR P/N 385-044
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3368 — REV. B — SHEET 2 OF 3
DATE 05.03.22		TITLE PEDAL LOCK — SCALE 1:2.5

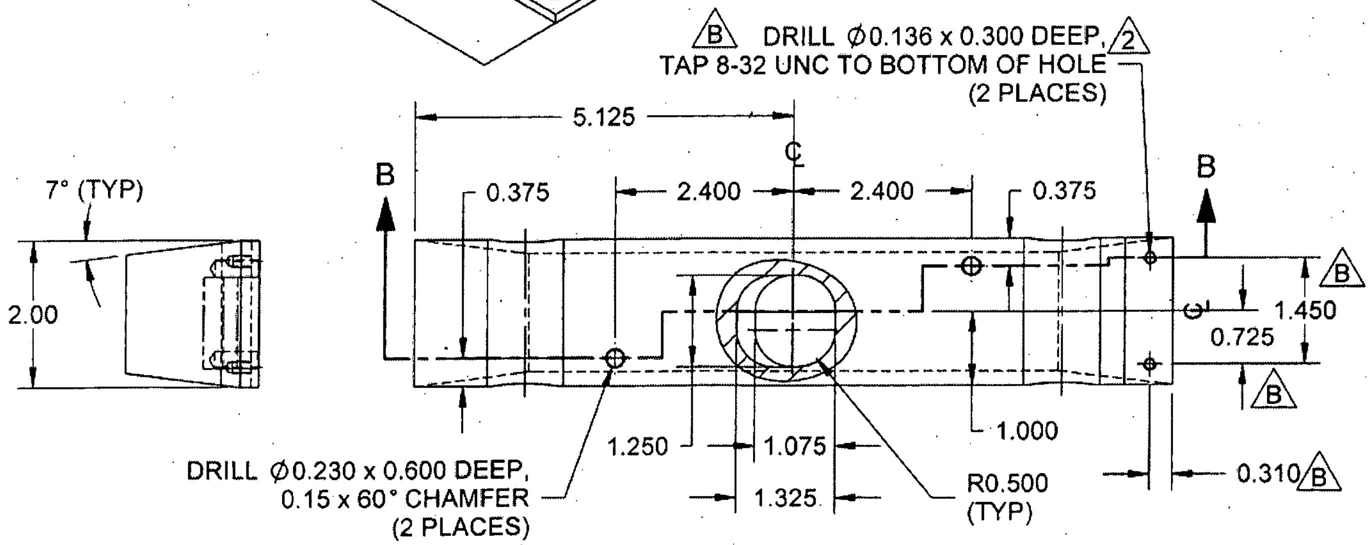
DART



SECTION B-B



RELEASED 05/04/28



D3368-1 BASE

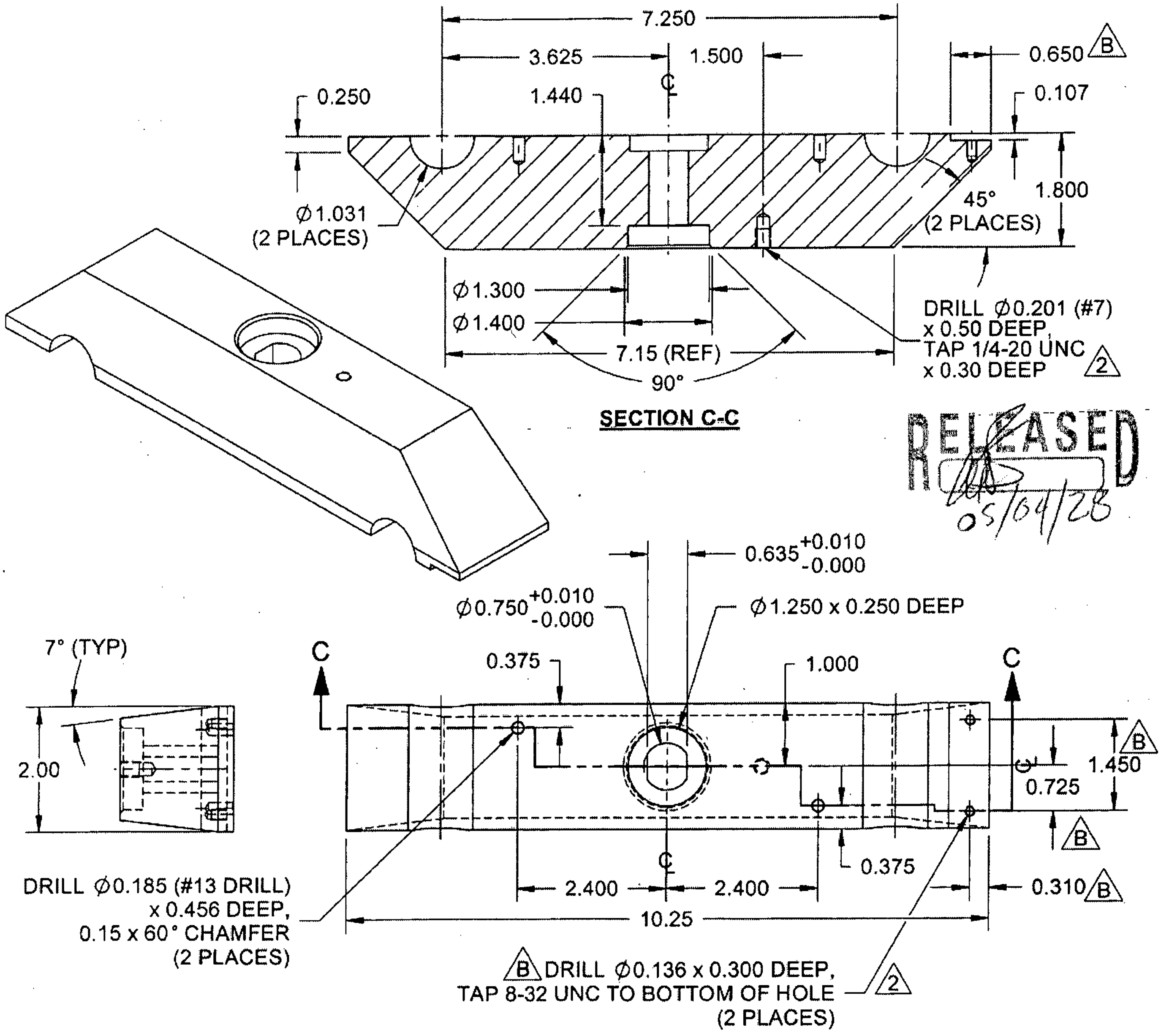
NOTES:

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
   (REF. DART SPEC. M6061T6B)
2) COVER INSIDE HOLES PRIOR PAINTING
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
   POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WITHOUT NOTICE
WORK ORDER
NO. 32806

DART

DESIGN	DRAWN BY	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3368 — REV. B — SHEET 3 OF 3
DATE 05.03.22		TITLE PEDAL LOCK — SCALE 1:2.5



D3368-3 COVER

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WORK ORDER
NO. 32806

NOTES:

1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
2) COVER INSIDE HOLES PRIOR PAINTING
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) ALL DIMENSIONS ARE IN INCHES
6) BREAK ALL SHARP EDGES 0.005 TO 0.010